

Date: Wednesday, 3/14/2007 12:25:39 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 31195	
Estimate Number : 12461	
P.O. Number : <u>N/A</u>	Part Number : D35081
This Issue : 3/14/2007 S.O. No. : <u>N/A</u>	Drawing Number : D3508 REV B
Prsht Rev. : NC	Project Number : <u>N/A</u>
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 28967	Material : <u>N/A</u>
Written By : <u>[Signature]</u>	Due Date : 3/30/2007 Qty: 8 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev:A New Issue 06-06-20 JLM	
Est Rev:B Now SS as per Rev B 06-12-15 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S20GA	304/316 .040 Sheet
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Comment: Qty.: 0.2489 sf(s)/Unit Total : 1.9908 sf(s)
 304 SS .038" THK (20GA)
 (M304S20GA)

Batch: 11103713

SAP 07/03/18

(8)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D3508
 Dwg Rev: B
 Prog Rev: B

2-Deburr if necessary

SAD 07/03/18

(8)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/03/18

(8)

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

SAD 07/03/19

(8)

5.0	BRAKE NC	NC BRAKE
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Comment: NC BRAKE

Deburr and form on brake using DT8326 and DT8261 as per Dwg D3508

SAD 07/03/22

(8)

MF 07-03-27

(8)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/04/05
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/14/2007 12:25:39 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 31195

Part Number: D35081

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



2070402



Comment: INSPECT WORK TO CURRENT STEP

7.0

POWDER COATING

POWDER COATING



m 10/601



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FL

07/04/03 (8)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



EP 07/04/04 (8)



Comment: INSPECT POWDER COAT

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

EP 07/04/04 (8)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



(8)

Comment: FINAL INSPECTION/W/O RELEASE

07/04/05

Job Completion



U 07/04/05

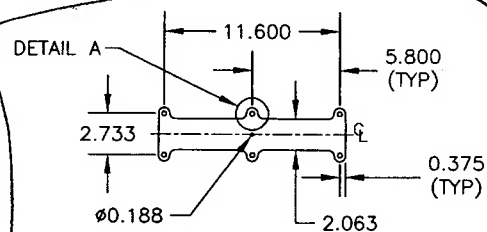
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

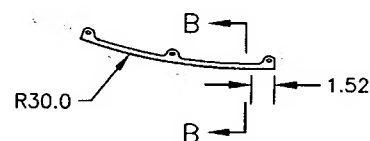
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

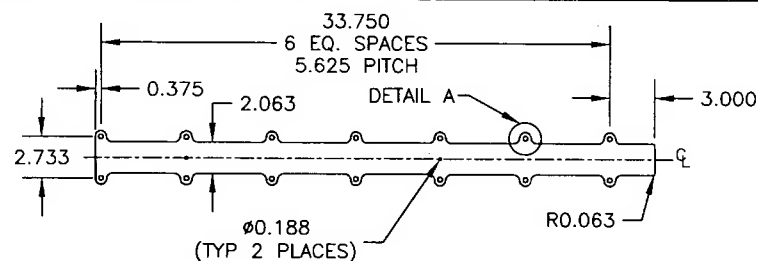
NOTE: Date & initial all entries



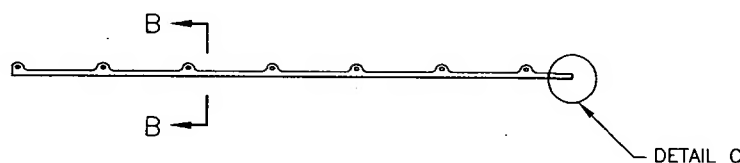
D3508-1 FLAT PATTERN



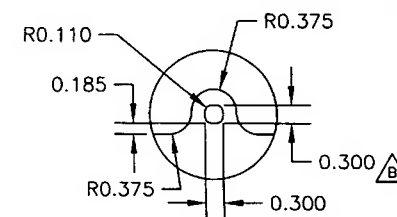
D3508-1 BENDING DETAIL



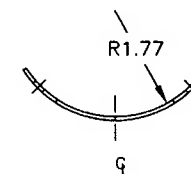
D3508-3 FLAT PATTERN



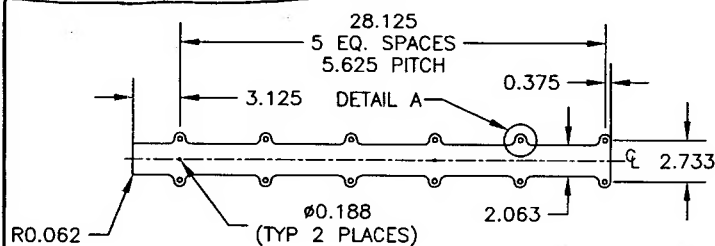
D3508-3 BENDING DETAIL



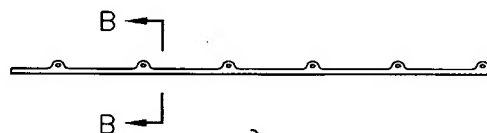
**DETAIL A
SCALE 1:2**



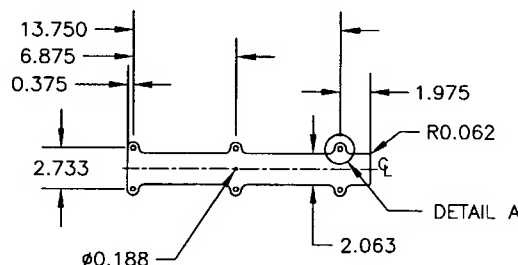
**SECTION B-B
SCALE 1:2**



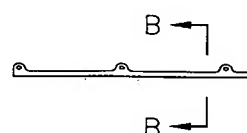
D3508-5 FLAT PATTERN



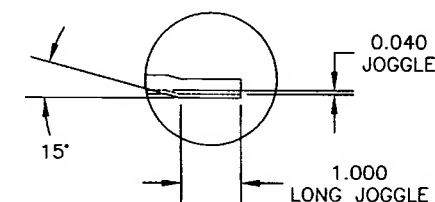
D3508-5 BENDING DETAIL



D3508-7 FLAT PATTERN



D3508-7 BENDING DETAIL



**DETAIL C
SCALE 1:2**

D3508-1/-3/-5/-7 WEARPLATE NOTES

- 1) MATERIAL: AISI 304/316 SS SHEET, 20 GAUGE (0.038 THICK) (REF DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED

06.12.12

NO. 31195
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING
RETURN TO
SHOP COPY

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B	06.10.27	CHANGE STAINLESS STEEL, WIDEN TAB
A	06.04.21	NEW ISSUE
DESIGN	DH	DRAWN BY
CHECKED	TH	APPROVED
DATE	06.10.27	
DRAWING NO.	D3508	REV. B
TITLE	WEARPLATE	SHEET 1 OF 1
		SCALE
		1:8

DART DART AEROSPACE USA, INC.
PORT HADLOCK, MA

DART AEROSPACE LTD		Work Order: 31195
Description: WearPlate		Part Number: 035081
Inspection Dwg: 35081	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	2.733	+/- 0.010	2.732	✓		Vern	
B	2.063	+/- 0.010	2.068	✓		Vern	
C	0.375	+/- 0.010	0.372	✓		Vern	
D	5.800	+/- 0.010	5.800	✓		Vern	
E	11.600	+/- 0.010	11.596	✓		Vern	
F	Ø0.182	+/- 0.010 +0.005	Ø0.182	✓		Vern	
G	0.300	+/- 0.010	0.302	✓		Vern	
H	0.300	+/- 0.010	0.304	✓		Vern	
I	0.033	+/- 0.010	0.035	✓		Vern	
J							
K							
L							
M							
N							
O							
P							
Q							
R							
S							
T							
U							
V							
W							
X							
Y							

Measured by: SAD	Audited by: J.L	Prototype Approval:	N/A
Date: 07/03/17	Date: 07/03/18	Date:	N/A

Rev	Date	Change	Revised by	Approved
		New Issue	KJ/RF	